

from i to f inch larger than the diameter D of the bushing. A groove E , $\frac{1}{2}$ to J inch wide, is cut immediately under the head, so that the emery wheel can pass clear over the part being ground.

Means for Preventing Loose Bushings from Turning. — In order to prevent the bushings from turning, in some shops a

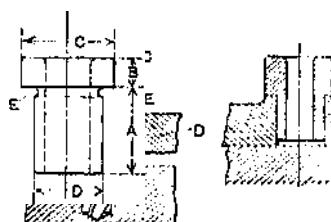


Fig. 4-

Fig. 5.

Fig. 6.

collar, with a projecting tail, as shown in Fig. 7, is forced over the head of the bushing. This arrangement also makes it easy to remove the bushing. The dog, as it is commonly called, is usually bent at the end of the tail, as shown in the illustration, one end resting against some part of the jig, the proportions of which the dog must suit. Sometimes the bent end is left straight,

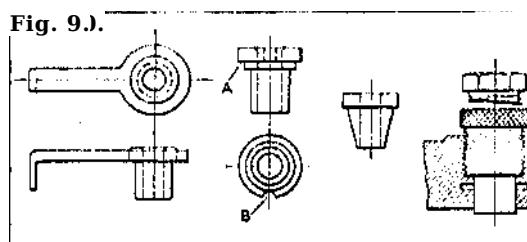


Fig. 7-

Fig. 8.

if there is a possibility for the tail to strike against some lug in the same

plane. The making of such dogs involves some extra expense, but it is very effective in avoiding troubles with bushings turning and working their way out of the holes. In some cases simply a hole is drilled in the shoulder of the bushing at the edge, and a corresponding pin is driven into the jig body. This serves the same purpose as the dog. It is probably cheaper,